

Date: Tuesday, 2/26/2008 8:02:08 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	RADIUS BLOCK
Job Number	37630			
Estimate Number	10822			
P.O. Number			Part Number	D2274
This Issue	2/26/2008	S.O. No. :	Drawing Number	D2274 REV F
Prsht Rev.	NC		Project Number	N/A
First Issue	/ /	Type : MACHINED PARTS	Drawing Revision	F
Previous Run	36624		Material	
Written By	:		Due Date	3/28/2008
Checked & Approved By	:	2/26/2008	Qty:	500
Comment	Est. H00.05.18	Added inspection level 8	Um:	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0750X00125	6061-T6 Bar .75" x .125"
	Comment: Qty.: 0.0962 f(s)/Unit Total : 48.0900 f(s) 6061-T6 Bar .75" x .125"	
	Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch 1103755	On 08/03/07
2.0	SHEAR	SHEAR
	Comment: SHEAR Shear blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2274	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.L 08/03/09
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble Deburr any rough edges after tumbling	
		J.L 08/03/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/03/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 8:02:08 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RADIUS BLOCK

Job Number: 37630

Part Number: D2274

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 HAND FINISHING1



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ML

08-03-10

X500

8.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

08/03/10

500

9.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STQ4

DS

08/03/11

X500

10.0 QC21



FINAL INSPECTION/W/O RELEASE



500

Comment: FINAL INSPECTION/W/O RELEASE

08/03/10

Job Completion



2008/3/12

500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37630
Description: Radius Block	Part Number:	D2274
Inspection Dwg: D2274	Rev: F	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

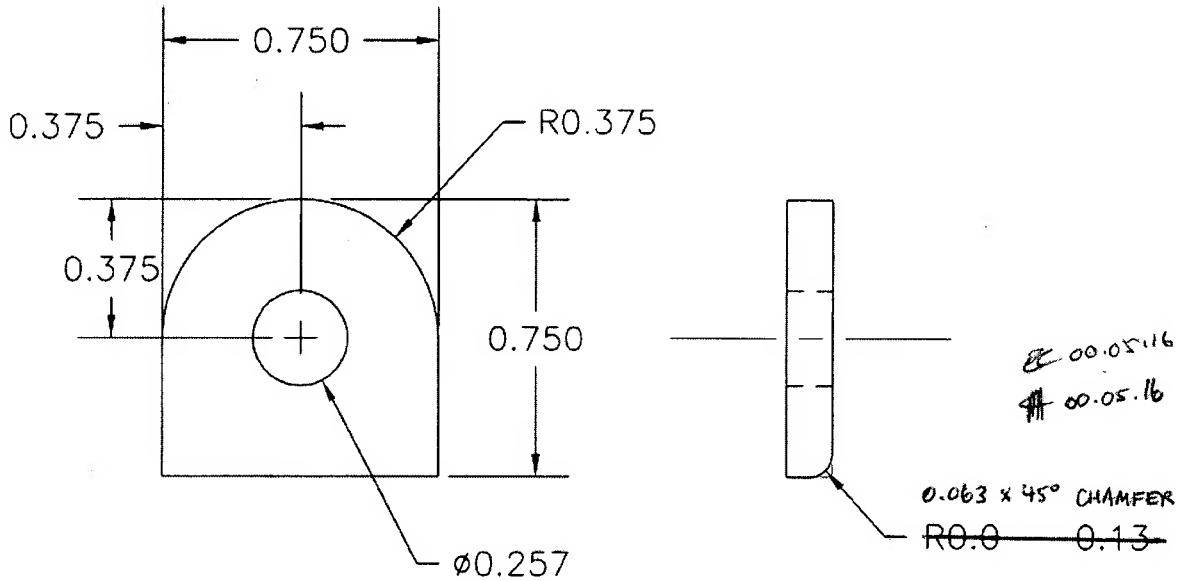
## X First Article Prototype

Measured by:	J.L	Audited by:		Prototype Approval:	
Date:	08/03/08	Date:		Date:	

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	

**DART**

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MJD	APPROVED AS	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11	TITLE RADIUS BLOCK		SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

**RELEASED**  
98/08/18 KE

SHOP COPY  
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WITHOUT NOTICE

WORK ORDER  
NO. 37630

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK  
OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

